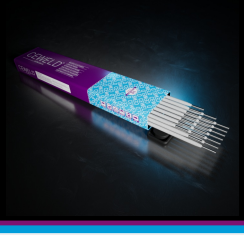


CEWELD 4316 Kb

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated electrode for corrosion-resistant Cr-Ni-steels with very low C-content

TOEPASSINGEN

The electrode is suitable for welding corrosion-resistant Cr-Ni-steels with extremely low C-content at working temperatures up to 350 °C.

EIGENSCHAPPEN

The weld deposit is scale-resistant up to approx. 800 °C in normal atmosphere and oxidizing gases. The weld deposit is capable of taking a high polish.

CLASSIFICATIE

AWS	A 5.4: E 308L-15
EN ISO	3581-A: E 19 9 L B 12
W.Nr.	1.4316
F-nr	1
FM	5

GESCHIKT VOOR

ISO 15608: 8.1 Austenitic ≤ 19 % Cr , TÜV 1000: Gr. 21 - 29, 9 % Ni,
1.4301, 1,4306, 1.4307, 1.4308, 1.4311, 1.4312, 1.6900, 1.6901, 1.6902, 1.6903, 1.9606, 1.4541, 1.4546, 1.4550
X 5 CrNi 18 10, X 2 CrNi 19 11, X 5 CrNi 18 9, G-X 6 CrNi 18 9, X 12 CrNi 18 9, G-X 8 CrNi 18 10, X 6 CrNi 18 10, X 10 CrNiTi 18 10, X 5 CrNi 18 10
AISI 304, 304H, 312, 321H, 347, 347H,
UNS S30409, S32109, S34709, S30400, S32100, S34700

GOEDKEURINGEN

CE

LASPOSITIES

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Cr	Ni
0.03	19	10

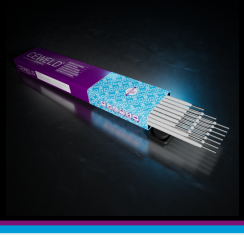
MECHANISCHE WAARDEN

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	330	550	35	70	HRc

HERDROGEN

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD 4316 Kb

4316 KB 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663411631